

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014526**Date Inspected:** 03-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 7CE

ABF Request No: 06032010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the hold back weld between edge panel and deck panel of OBG segment 7CE. Inspection was carried out on repair areas. The weld designations are as follows.

CA040-004 (OBG 7CE-D.P to E.P, Bike path side)

ULTRASONIC INSPECTION

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

OBG SEGMENT 8BW

ABF Request No: 06032010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the hold back weld between edge panel and deck panel of OBG segment 8BW. Inspection was carried out on repair areas. The weld designations are as follows.

CA049-006 (OBG 8BW-D.P to E.P, Counter weight side)

ULTRASONIC INSPECTION

OBG SEGMENT 8CW

ABF Request No: 06032010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the hold back weld between edge panel and deck panel of OBG segment 8CW. Inspection was carried out on repair areas. The weld designations are as follows.

CA053-006 (OBG 8CW-D.P to E.P, Counter weight side)

ULTRASONIC INSPECTION

OBG SEGMENT 9AE

ABF Request No: 06032010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the hold back weld between edge panel and deck panel of OBG segment 9AE. Inspection was carried out on repair areas. The weld designations are as follows.

CA058-006 (OBG 9AE-D.P to E.P, Bike path side)

CA057-002 (OBG 9AE-D.P to E.P, Cross beam side)

ULTRASONIC INSPECTION

OBG SEGMENT 8BW-8AW

ABF Report No: UT-8W-031

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the deck panel splice weld between OBG segment 8AW and 8BW. The weld designations are as follows.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

OBW8-002, 003, 004 (OBG 8AW-8BW-D.P)

ULTRASONIC INSPECTION

OBG SEGMENT 8BW-8AW

ABF Report No: UT-8W-032

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the edge panel splice weld between OBG segment 8AW and 8BW. The weld designations are as follows.

OBW8-001, 005 (OBG 8AW-8BW-E.P)

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 7CE

ABF Request No: 06032010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the between edge panel and deck panel of cross OBG segment 7CE. Inspection was carried out on repair areas. Weld identification number was.

CA040-004 (OBG 7CE-D.P to E.P, Bike path side)

No relevant indications were observed.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 8BW

ABF Request No: 06032010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the between edge panel and deck panel of cross OBG segment 8BW. Inspection was carried out on repair areas. Weld identification number was.

CA049-006 (OBG 8BW-D.P to E.P, Counter weight side)

No relevant indications were observed.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 8CW

ABF Request No: 06032010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the between edge panel and deck panel of cross OBG segment 8CW. Inspection was carried out on repair areas. Weld identification number was.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

CA053-006 (OBG 8CW-D.P to E.P, Counter weight side)

No relevant indications were observed.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 9AE

ABF Request No: 06032010-1

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the between edge panel and deck panel of cross OBG segment 9AE. Inspection was carried out on repair areas. Weld identification number was.

CA058-006 (OBG 9AE-D.P to E.P, Bike path side)

CA057-002 (OBG 9AE-D.P to E.P, Cross beam side)

No relevant indications were observed.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
----------------------	-----------------	-----------------------------

Reviewed By:	Dawson,Paul	QA Reviewer
---------------------	-------------	-------------